

# Work Order ID 52678

October 7, 2009 8:11:32 AM



Page 1

Item ID: D3846-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: GASKET

Start Date: 10/09/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/16/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3846

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3846

Dwg Rev: 13

Prog Rev: 13

2-Deburr if necessary

MAT NOT PULLED

B9-10-10



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B9-10-10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 52678

October 7, 2009 8:11:33 AM

Page 2

Item ID: D3846-5

Accept

Revision ID: B

Item Name: GASKET

Start Date: 10/09/09 Start Qty: 4.00

Required Date: 10/16/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

⇒ 502/10/13

(76)

4

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: FINISHING 0.00

0.00

Packaging

Memo

0.00

Packaging

PC9/10/13 (11)

140

QC21- Final Inspection - Work Order Release 0.00

0.00

QC

Memo

0.00

QC

Quality Control

09/10/19 HJ

W 87.10.16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

October 7, 2009 8:11:32 AM

Page 1

Work Order ID: 52678

Parent Item: D3846-5RevB

Parent Item Name: GASKET

Comments:

Start Date: 10/09/09

Required Date: 10/16/09

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MNEO60S.063                     |                        | Purchased     | No          |                     |                  | 100             | sf                 | 61.6034        | 4.1116                   |               |                |        |



NEOPRENE SHEET 0.063

B9-10-10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

61.60335853

111853

-4.147E-05

112508

61.6034

112866

112866

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                       |        |                      |
|-----------------------|--------|----------------------|
| DART AEROSPACE LTD    |        | Work Order: 52679    |
| Description: Gasket   |        | Part Number: D3846-5 |
| Inspection Dwg: D3846 | Rev: B | Page 1 of 1          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.219            | +0.005/-0.001 | .220             | *      |        |                      |          |
| 0.300 x 0.300     | +/-0.010      | .361 x .307      | *      |        |                      |          |
| 2.39              | +/-0.030      | 2.380            | *      |        |                      |          |
| 3.20              | +/-0.030      | 3.194            | *      |        |                      |          |
| 4.02              | +/-0.030      | 4.018            | *      |        |                      |          |
| 1.69              | +/-0.030      | 1.682            | *      |        |                      |          |
| 15.80             | +/-0.030      | 15.80            | *      |        |                      |          |
| 31.61             | +/-0.030      | 31.61            | *      |        |                      |          |
| 8.49              | +/-0.030      | 8.48             | *      |        |                      |          |
| 18.00             | +/-0.030      | 18.00            | *      |        |                      |          |
| 34.98             | +/-0.030      | 35.00            | *      |        |                      |          |
| 0.063             | +/-0.010      | .056             | *      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

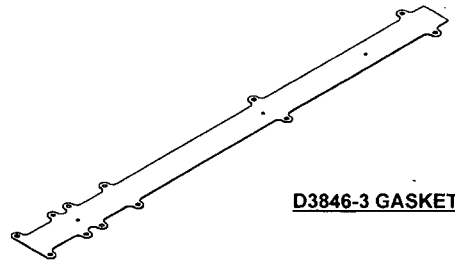
|                 |                |                     |     |
|-----------------|----------------|---------------------|-----|
| Measured by: IB | Audited by: S  | Prototype Approval: | N/A |
| Date: 9-10-10   | Date: 07/10/13 | Date:               | N/A |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 09.09.15 | New Issue | KJ         | JA       |

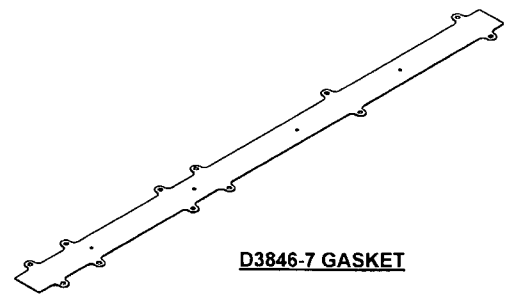
WFO 52678



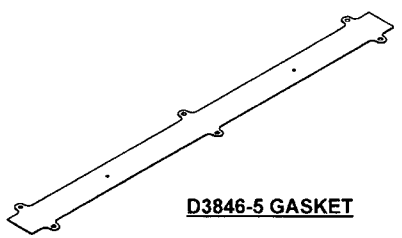
**D3846-1 GASKET**



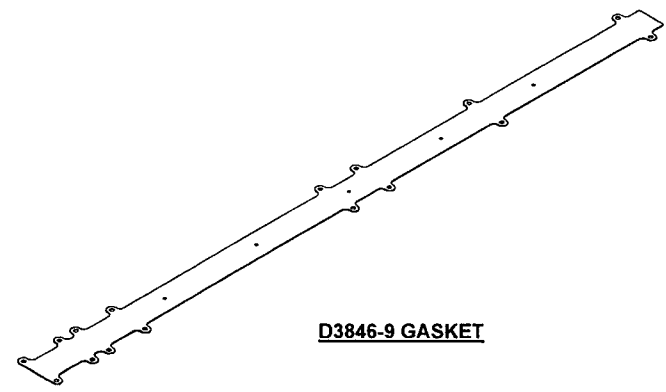
**D3846-3 GASKET**



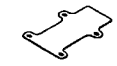
**D3846-7 GASKET**



**D3846-5 GASKET**



**D3846-9 GASKET**



**D3846-11 GASKET**

RELEASED  
09/15/10

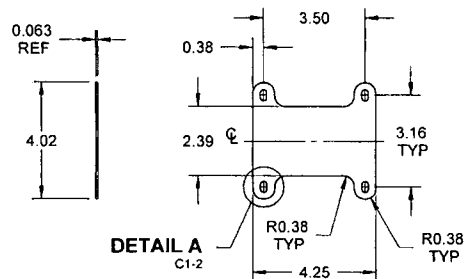
**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER  
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3846-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:  
D3846-1 = 0.03 lbs  
D3846-3 = 0.25 lbs  
D3846-5 = 0.20 lbs  
D3846-7 = 0.26 lbs  
D3846-9 = 0.35 lbs  
D3846-11 = 0.04 lbs

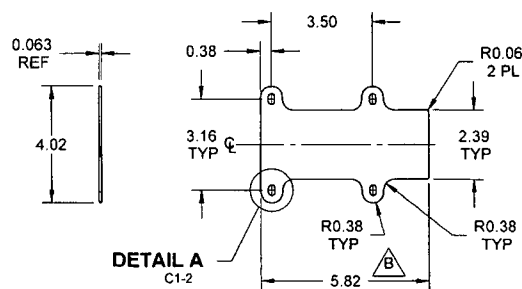
|            |   |   |              |
|------------|---|---|--------------|
| B          | 5.82 WAS 6.25 (ZN C4-2); 45.28 WAS 45.71 (ZN A4-3); 6.32 WAS 6.75 (ZN B2-3) | RF  | 09.06.30     |
| A          | NEW ISSUE   | RF  | 09.03.30     |
| REV.       | DESCRIPTION   | BY  | DATE         |
| DESIGN     | RF  | <b>DART AEROSPACE USA, INC.</b>   |              |
| DRAWN      | RF  | PORT HADLOCK, WA  |              |
| CHECKED    | AW  | DRAWING NO.   | REV. B       |
| MFG. APPR. | SL  | D3846   | SHEET 1 OF 4 |
| APPROVED   | MP  | TITLE   | SCALE        |
| DE APPR.   | JK  | GASKET  | NTS          |
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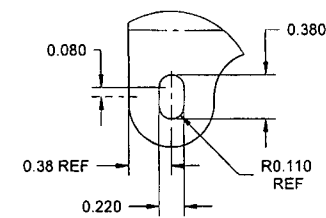
52678



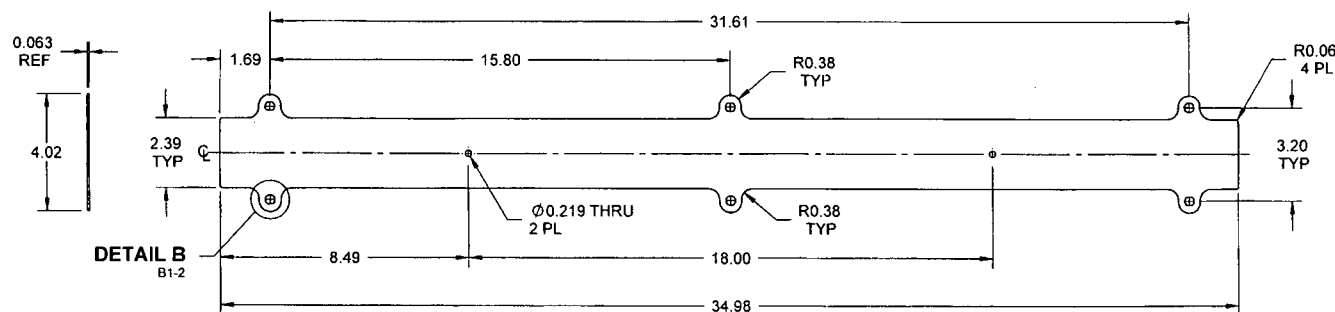
**D3846-1 GASKET**



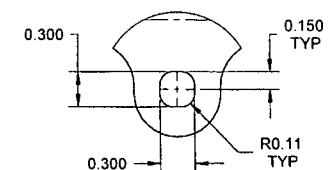
**D3846-11 GASKET**



**DETAIL A** C5-2  
TYP, SCALE 4X C7-2



**D3846-5 GASKET**

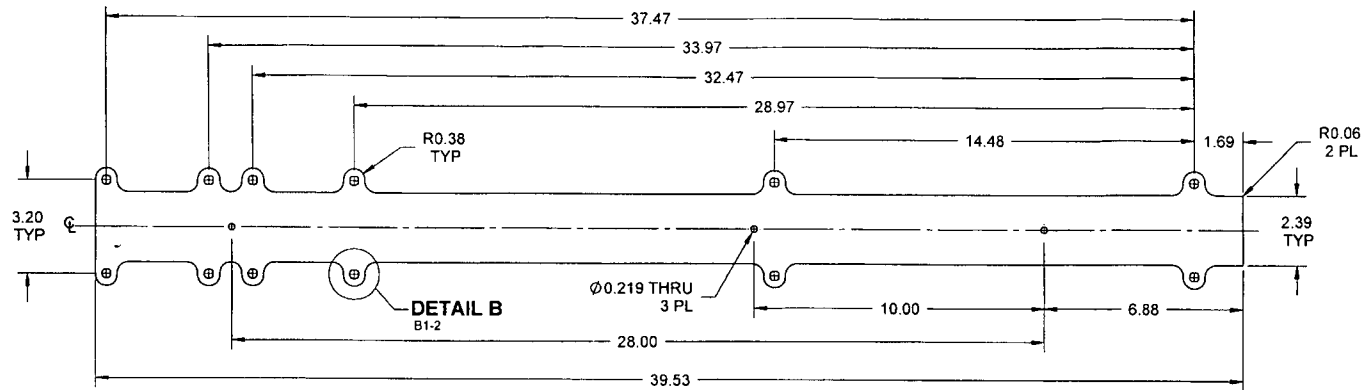
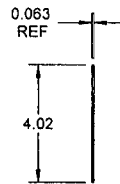


**DETAIL B** A7-2  
TYP, SCALE 4X C5-3  
B7-3  
C5-4

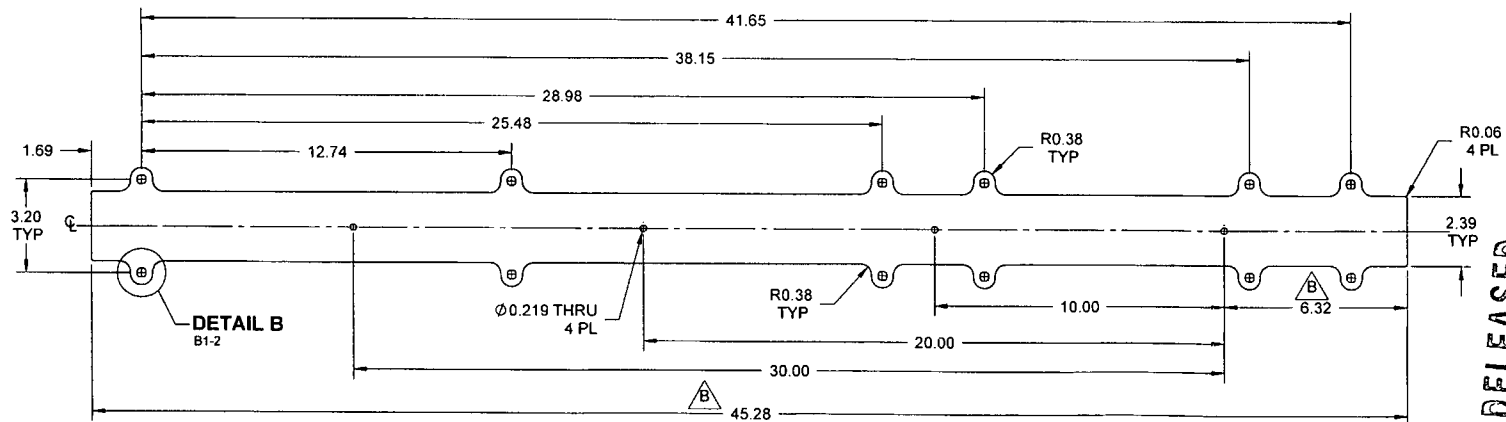
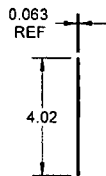
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09/07/15

|   |          |  |              |
|---|----------|--|--------------|
| DESIGN  | RF       | <b>DART AEROSPACE USA, INC.</b>              |              |
| DRAWN   | RF       | PORT HADLOCK, WA                             |              |
| CHECKED   | RF       | DRAWING NO.                                  | REV. B       |
| MFG. APPR.  | RF       | D3846  | SHEET 2 OF 4 |
| APPROVED  | RF       | TITLE  | SCALE        |
| DE APPR.  | RF       | GASKET                                       | NTS          |
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W/052678






**D3846-3 GASKET**

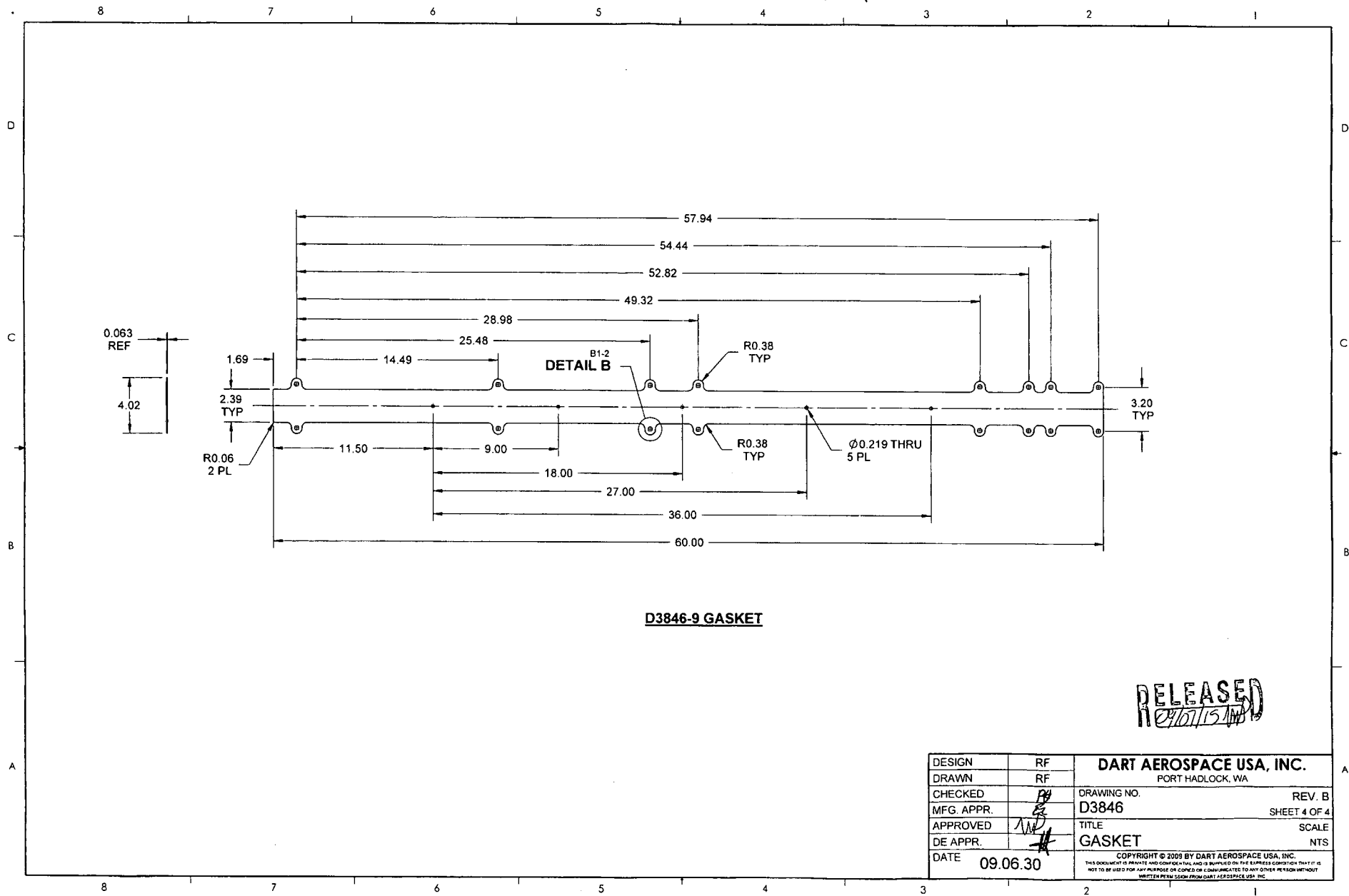


**D3846-7 GASKET**

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|---|---|--|--------------|
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| DRAWN   | RF  | PORT HADLOCK, WA                             |              |
| CHECKED   | RF  | DRAWING NO.                                  | REV. B       |
| MFG. APPR.  |  | D3846  | SHEET 3 OF 4 |
| APPROVED  |  | TITLE  | SCALE        |
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W/O 52678



**D3846-9 GASKET**

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10/15/10

|            |                    |   |              |
|------------|--------------------|---|--------------|
| DESIGN     | RF                 | <b>DART AEROSPACE USA, INC.</b>   |              |
| DRAWN      | RF                 | PORT HADLOCK, WA  |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.   | REV. B       |
| MFG. APPR. | <i>[Signature]</i> | <b>D3846</b>  | SHEET 4 OF 4 |
| APPROVED   | <i>[Signature]</i> | TITLE   | SCALE        |
| DE APPR.   | <i>[Signature]</i> | <b>GASKET</b>   | NTS          |
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